

Work Order ID 74602

Monday, October 03, 2011 4:01:14 PM

Page 1

Item ID: D2932-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle RH Out, 206

Start Date: 10/3/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: H

Date: 11-10-4

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2932

Rev C

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

B.A 11/11/16

0.00

F.K 11/11/17

8

3

PTO

Memo

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

B.A 11/11/16

0.00

F.K 11/11/17

8

3

Memo

Machine Keyway and inspect per attached dimension sheet

120



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

B.A 11/11/16

0.00

F.K 11/11/17

8

3

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2932-2 PAR #: 1/A Fault Category: Mechan NCR: Yes No QQA: 1 Date: 11/11/24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 11/11/24

NCR: <u>11-1014</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/17	100	Part had a vibration issue on 4 axis due to the fact that the 3rd op., the vise was too tight, that in turned falsed dimension "0".	<u>11/18/11</u> <u>QST1042</u>	Scrap. Skid notch too shallow.	F.K. <u>11/11/17</u>	<u>11/11/22</u>	<u>11/18/11</u> <u>QST1042</u>	<u>11/11/18</u>
11/11/18	100	Qty + 2 Parts have skid rake like location too thin. @.246 should be 0.265 Before measuring is let.	<u>11/18/11</u> <u>QST1042</u>	Scrap Scrap.	F.K. <u>11/11/18</u>	<u>11/11/22</u>	<u>11/18/11</u> <u>QST1042</u>	<u>11/11/18</u>
		P.C. L.O.A. operator attempted to stop chatter by placing a Bar Shim under a Bar.					<u>11/18/11</u> <u>QST1042</u>	<u>11/11/18</u>

NOTE: Date & initial all entries

Work Order ID 74602

Monday, October 03, 2011 4:01:14 PM



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Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 10/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

and 11/11/22

8

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

8xφ m-f 11/11/22

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

8xφ m-f 11/11/22

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:00

3:30

3200F

M118434

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74602

Page 3

Monday, October 03, 2011 4:01:14 PM

Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 10/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 BR 11-11-22

170

Identify as per dwg & Stock Location: ST 428 0.00



Packaging

Memo

0.00

Packaging

(82) SP 11-11-23

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/11/23

MF
11-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 4:01:52 PM

Page 1

Work Order ID: 74602

Parent Item: D2932-2

Parent Item Name: Saddle RH Out, 206



Start Date: 10/3/2011

Start Qty: 8.00

Required Date: 10/5/2011

Required Qty: 8.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	73.0000	1	8			

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	8	
72226	8	
MAT44	65	
72226	5	
73769	60	

74650
74650

8.0
3.0
B.A 11/11/16
FK 11/11/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74602
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				5 Data/
				1	2	3	4	
A	0.100	0.140		0.132	0.132	0.132		0.133
B	0.100	0.140		0.132	0.132	0.135		0.133
C	0.100	0.140		0.121	0.131	0.130		0.121
D	0.210	0.230		0.221	0.222	0.219	0.222	0.222
E	1.245	1.255		1.250	1.250			1.250
F	1.245	1.255		1.250	1.250			1.250
G	2.495	2.505		2.500	2.500			2.500
H	0.510	0.515		0.512	0.512			0.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		0.260	0.260	0.257	0.257	0.257
L	0.312	0.317		0.314	0.314			0.314
M	0.235	0.240		0.2375	0.238			0.236
N	0.100	0.140		0.135	0.116	0.112	0.114	0.112
O	0.540	0.560		0.548	0.546	0.540	0.540	0.548
P	0.490	0.510		0.500	0.500			0.499
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.490	2.490	2.490	2.490	2.490
S	0.240	0.270		0.252	0.250			0.253
T	0.100	0.180		0.135	0.135			0.135
U	1.625	1.635		1.630	1.630			1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		0.316	0.316	0.316	0.316	0.316
X	1.125	1.145		1.1352	1.1375	1.135	1.135	1.136
Y	1.565	1.585		1.574	1.5737	1.5747	1.5732	1.574
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
AF								
AG								
AH								
Accept/Reject								

Measured by:	B.A. / F.K.
Date:	11/11/16 / 11/11/17

Audited by:	amf
Date:	11/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74602
Description: 206 Saddle, Outboard, Right side		Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	By	Date
A	0.100	0.140		.133	.134	.134	.133		
B	0.100	0.140		.133	.134	.134	.133		
C	0.100	0.140		.120	.118	.118	.118		
D	0.210	0.230		.218	.225	.219	.218		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.260	.260	.260		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.236	.235	.236	.236		
N	0.100	0.140		.111	.113	.113	.112		
O	0.540	0.560		.550	.549	.549	.550		
P	0.490	0.510		.501	.499	.498	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.251	.251	.252	.251		
T	0.100	0.180		.135	.138	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.1354	1.1363	1.1357	1.135		
Y	1.565	1.585		1.572	1.5736	1.5738	1.5727		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	PK. PK.
Date:	11/11/17

Audited by:	amf
Date:	11/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 74602
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	10	2	3	4		
A	0.100	0.140		.134	.134				
B	0.100	0.140		.133	.135				
C	0.100	0.140		.119	.119				
D	0.210	0.230		.219	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.512	.512				
I	1.572	1.582		1.577	1.572				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.260	.260				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.236	.236				
N	0.100	0.140		.112	.112				
O	0.540	0.560		.550	.549				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.496	2.490				
S	0.240	0.270		.252	.252				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.1351	1.1357				
Y	1.565	1.585		1.5723	1.573				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>FK</i>
Date: 11/11/18

Audited by: <i>amf</i>
Date: 11/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

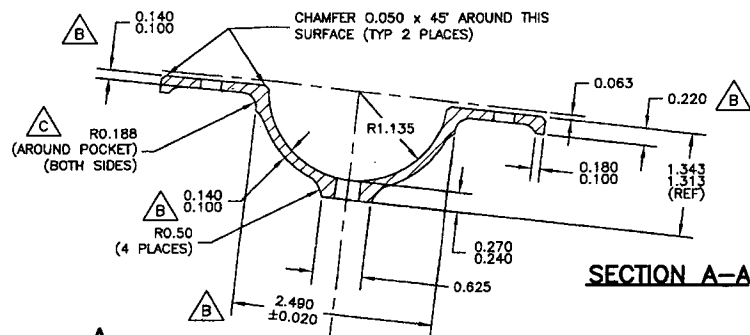
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

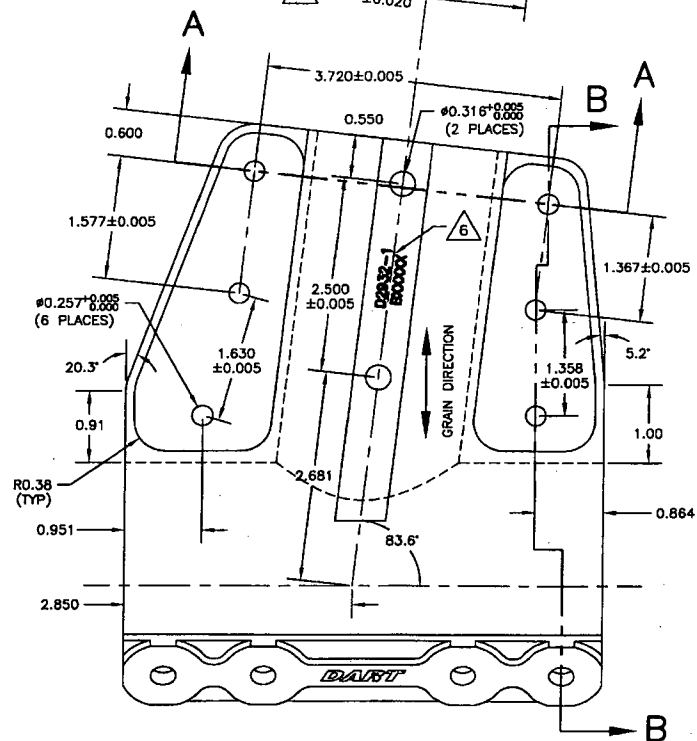
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

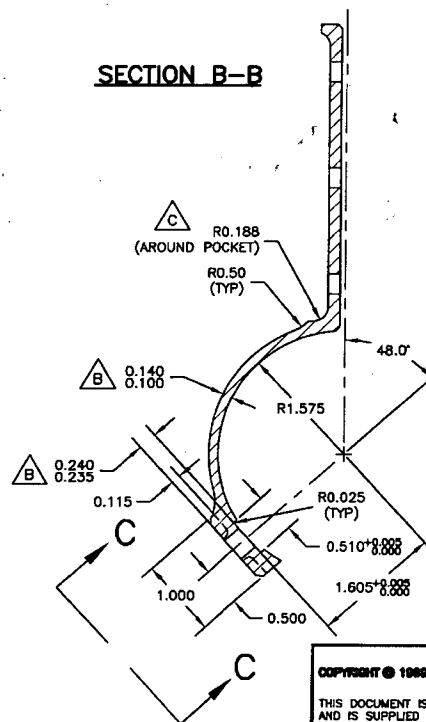
NOTE: Date & initial all entries



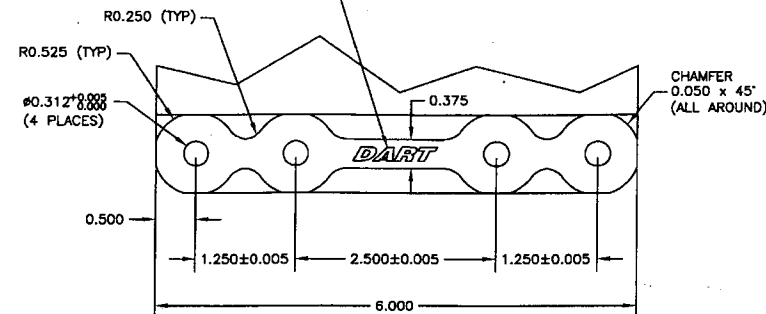
SECTION A-A



SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2932
DATE		TITLE SADDLE OUTSIDE
06.11.09		SCALE 2:3

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RELEASED
07-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries